

# Work Order ID 79180

January-23-12 10:46:24 AM

**\*79180\***

Page 1

Item ID: D2804-2 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Bracket  
 Start Date: 23/01/2012 Start Qty: 10.00 **\*10\*** Cust Item ID:  
 Required Date: 06/02/2012 Req'd Qty: 10.00 **\*10\*** Customer:  
 Reference:

Approvals: Process Plan: H.C.J. Date: 12/01/23 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2804	Rev C

100 0.00  
**\*100\*** FLOW WATER JET

Waterjet Memo 0.00  
 FLOW CNC Waterjet 1-Cut as per File D2804-1-2\_BLANK  
 6061, 500x 10 Dwg Rev: C  
 Prog Rev: C  
 2-Deburr if necessary

B12-1-30

(10)

110 0.00  
**\*110\*** HAAS CNC VERTICAL MACHINING #1

HAAS 1 Memo 0.00  
 HAAS CNC vertical machine #1 Machine as per folio FA103

56/100

1210.130

(x10)

120 0.00  
**\*120\*** QC2- Inspect parts off machine FAI/FAIB

QC Memo 0.00  
 Quality Control

56/100

1210.130

(x10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 <b>*130*</b> QC Quality Control	QC8- Inspect parts - second check  Memo	0.00  0.00		20 12.2.2		10	4		
140 <b>*140*</b> HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00  0.00							10 X Ø M-L 12/02/02
150 <b>*150*</b> QC Quality Control	QC3- Inspect Part Finish  Memo	0.00  0.00							10 BK 1222

W/O:		WORK ORDER CHANGES					
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Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: <i>ST 149</i>	0.00							
<b>*160*</b>									
Packaging	Memo	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
<b>*170*</b>									
QC	Memo	0.00							
Quality Control									

*EP 12/02/08 @ 10*

*M.L.J 12/02/08*

*M.L.J 12/02/08*

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

# Picklist Print

January-23-12 10:46:28 AM

Work Order ID: 79180

\*79180\*

Parent Item: D2804-2

\*D2804-2\*

Parent Item Name: Bracket

Start Date: 23/01/2012

Required Date: 06/02/2012

Start Qty: 10.00

Required Qty: 10.00

**Comments:**

IPP A00.11.06New IssueEC  
 IPP B06.05.30 Blanks on wtjetEC  
 IPP Rev:C As per Rev C 06-11-09 JLM  
 IPP Rev:D Removed Tumbling 08-09-10 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6B0.500X10.00  
0

Purchased

No

f

24.1000

7.5

\*M6061T6B0 500X10 000\*

\*\*

B12-1-30

6061-T6 Bar .500 x 10.00

Location

Loc Qty

Loc Code

MAT004

24.1

119513

24.1

M120421

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



DART AEROSPACE LTD		Work Order: 79180
Description: STA 155 Bracket		Part Number: D2804-2
Inspection Dwg: D2804	Rev: C	Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.125	+/-0.010	.127	✓		Dial Caliper	OK 05
0.125	+/-0.010	.128	✓			
R0.125	+/-0.010	.125	✓			
0.250	+/-0.010	.250	✓			
0.250	+0.000/-0.005	.246	✓			
0.875	+0.000/-0.001	.8715	✓			
R0.062	+/-0.010	.062	✓			
Ø0.757	+0.005/-0.000	.7575	✓			
R0.625	+/-0.010	.625	✓			
12.304	+/-0.005	12.704	✓			
Ø0.507	+0.000/-0.001	.5067	✓			
0.437	+0.000/-0.001	.4365	✓			
0.608	+0.000/-0.001	.6075	✓			
Ø0.191	+0.005/-0.000	.191	✓			
1.420	+0.001/-0.001	1.420				
0.250 deep	+/-0.010	.245	✓			
6.933	+/-0.005	6.933	✓			
7.578	+/-0.005	7.578	✓			
0.500	+/-0.010	.505	✓			

Measured by: <i>SK / ml</i>	Audited by: <i>RF</i>	Prototype Approval:	N/A
Date: 12/01/10	Date: 12.2.2	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.12.10	New Issue	KJ/JLM	
B	05.04.25	Added 0.500 dimension	KJ/JLM	
C	06.11.10	Revised per drawing revision C	KJ/JLM	<i>BE</i>

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

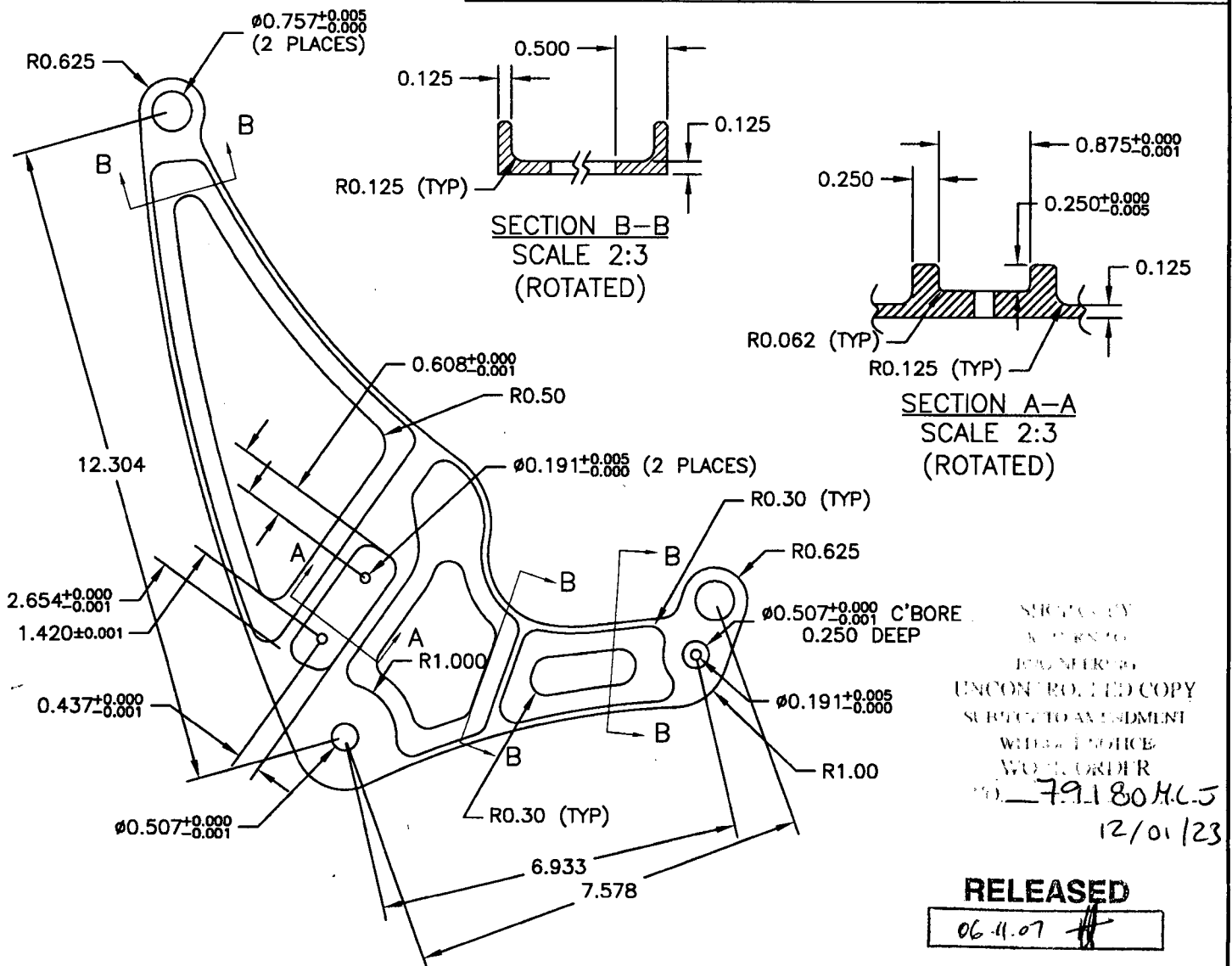
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**DART**

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2804	REV. C SHEET 1 OF 2
DATE 06.10.16		TITLE STA 155 BRACKET	SCALE 1:3
A	00.11.07	NEW ISSUE	
B	04.11.22	ADD CUTOUTS & -043/-044	
C	06.10.16	CHANGE GEOM. TO ADD CLEARANCE	

**D2804-1 BRACKET (SHOWN). D2804-2 BRACKET (OPPOSITE)**

- 1) MACHINE PER DRAWING FILE "D2804-1C.SLDPRT"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

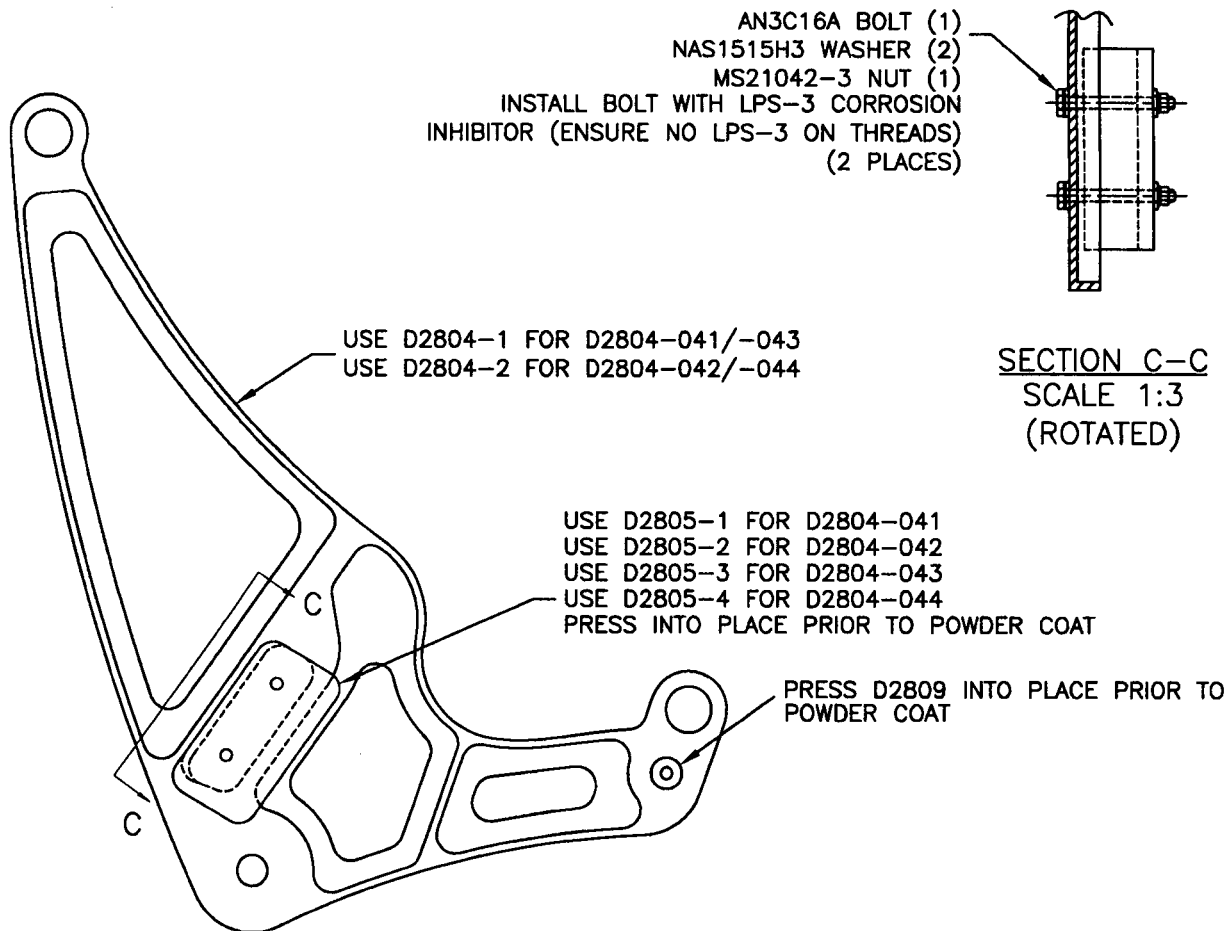
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**DART**

79180

DESIGN CP	DRAWN BY CP	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2804 REV. C SHEET 2 OF 2
DATE 06.10.16	TITLE STA 155 BRACKET	SCALE 1:3



**RELEASED**

06.11.07 [Signature]

**D2804-041/-043 BRACKET ASS'Y (SHOWN).**

**D2804-042/-044 BRACKET ASS'Y (OPPOSITE)**

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)  
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

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